

Work Order ID 107838

October-03-13 3:24:47 PM

107838

Page 1

Item ID: D3405-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Gh Lug

Start Date: 10/03/13

Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/16/13

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3405	Rev B								
100	FLOW WATER JET	0.00							
100		0.00							
Waterjet	Memo								
FLOW CNC Waterjet	1-Cut as per Dwg D3405								
304 .125"	Dwg Rev: B								
	Prog Rev: B								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110		0.00							
QC	Memo								
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120		0.00							
QC	Memo								
Quality Control									

DAS
27
9-89

13 10.7

Jm13-10-04

Jm13-10-04

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Page 2

Item ID: D3405-041

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Gh Lug

Start Date: 10/03/13 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/16/13 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Brake NC

Brake NC

NC BRAKE

Memo

1-Deburr

2-Form using DT8204 as per Dwg D3405

3- use DT9681 to check if correct forming

0.00

0.00

0.00

0.00

0.00

0.00

DAS

27

9-89

13 10.9

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

150

150

Large Fab

Large Fab

Large Fab

Memo

Weld as per Dwg D3405 use DT8484

Identify as D3405-041

S

S

S

SB
13/10/09

1340-16

MSC

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107838

Page 3

Item ID: D3405-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gh Lug

Start Date: 10/03/13 Start Qty: 2.00

~~*2*~~ 5
~~*2*~~

Cust Item ID:

Required Date: 10/16/13 Req'd Qty: 2.00

Customer:

Reference:

Run Start ***NR1***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC 13/10/16

5x

160

QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

DAS
27
9-89

13/10/14

9

170

QC

Memo

0.00

Quality Control

180

White Gloss (Ref 4.3.5.2) per QSI005 4.3-Steel

0.00

3 φ 13-10-17

DAS
34
9-89

180

Powdercoat

Memo

0.00

ATTN: DRAB GREEN

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11/26/15
3:15
400
345

3

QC 3

DAS
27
9-89

13-10-18 / 1D+STOCK → ST468

DAS
33
9-89

3

12-10-18

Work Order ID 107838

107838

Page 4

October-03-13 3:24:47 PM

Item ID: D3405-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Gh Lug

Start Date: 10/03/13 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/16/13 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject
Qty Qty Number Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

DAS
27
9-89

13-10-16

See sheet 3 for
sign offs

200

Identify as per dwg & Stock Location:

0.00

200

Packaging

Memo

0.00

Packaging

PPP105715

2X

DAS
28
9-89

13-10-16

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

13/10/27/17

13-10-17

Picklist Print

October-03-13 3:24:47 PM

Page 1

Work Order ID: 107838
Parent Item: D3405-041
Parent Item Name: Gh Lug

Start Date: 10/03/13
Start Qty: 2.00

Required Date: 10/16/13
Required Qty: 2.00

Comments: IPP A05.09.01New issueKJ/JLM
IPP B 09.01.28 rev.B drawing EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3404-1		Manufactured	No			100	Each	62.0000	1	2			
GHW/ Lug													

Location	Loc Qty	Loc Code
WA001	62	
103024	27	
106247	35	

M304S11GA		Purchased	No			150	sf	233.0633	0.154	①			
304/316 0.125 Sheet													

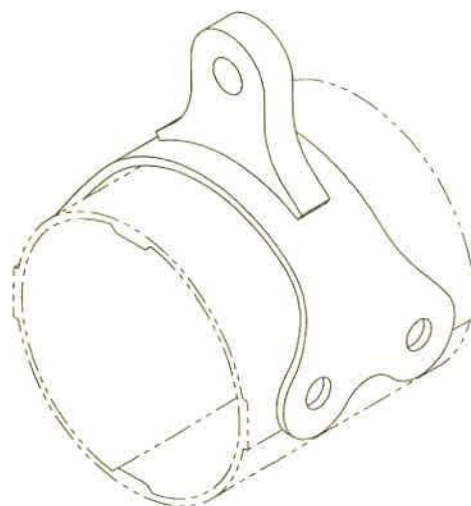
Location	Loc Qty	Loc Code
MAT020	233.0632632	
122521	19.1432632	
124445	44.5	
M126075	169.42	

126075

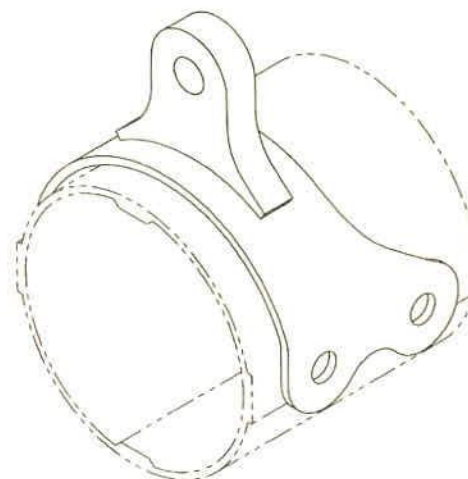
12-10-16
JBC

gm310-04

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



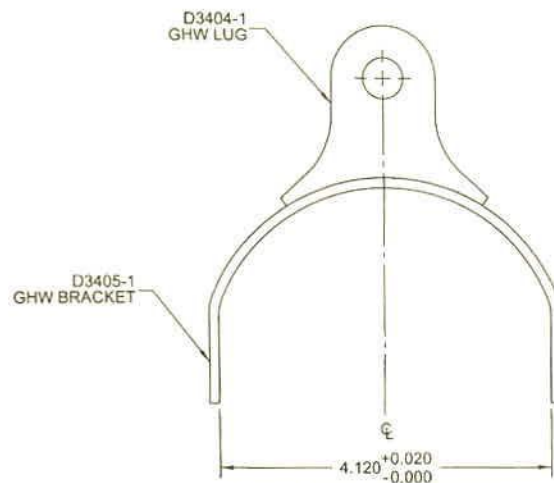
D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

RELEASED
08/12/18 MFS

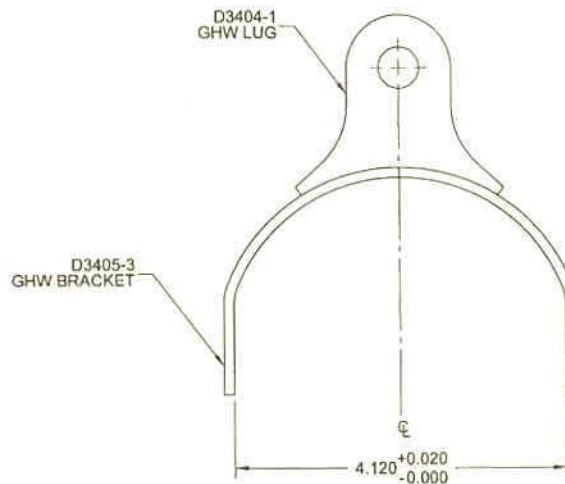
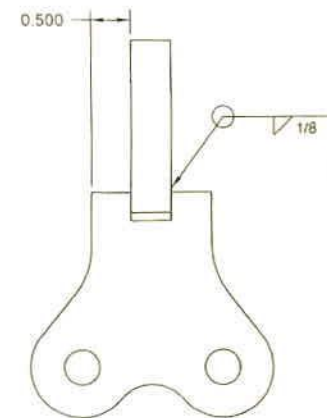
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
; IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

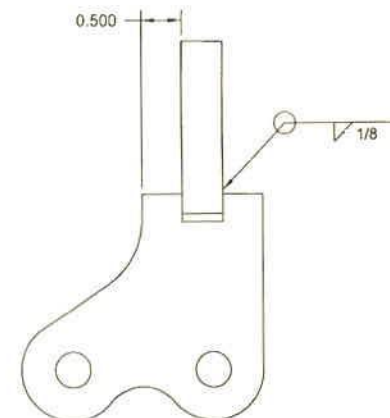
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.	AJS	08.09.19
A	NEW ISSUE	PH	05.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
DATE	08.09.19	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE BASIS OF CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



D3405-041 LUG ASSEMBLY

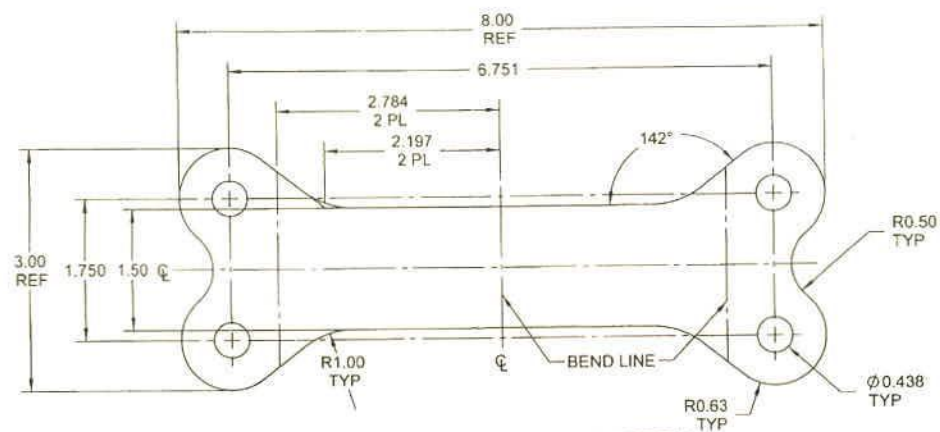


D3405-043 LUG ASSEMBLY

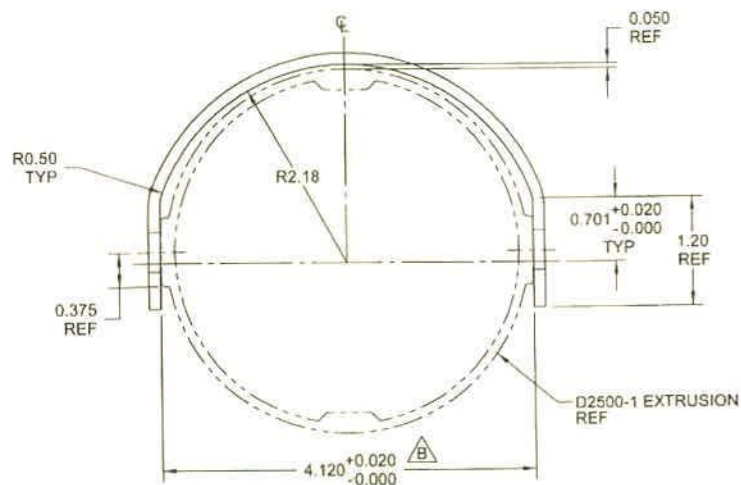


RELEASED
6/12/18

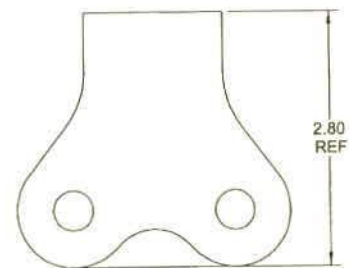
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3405	REV. B
MFG. APPR.			SHEET 2 OF 4
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DATE	08.09.19		



D3405-1F GHW BRACKET FLAT PATTERN







D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



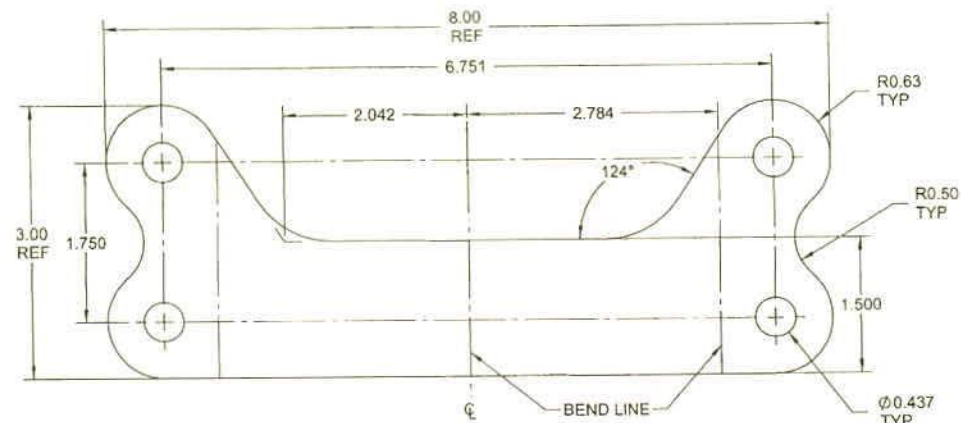
SIDE VIEW FOR REF ONLY

NOTES:

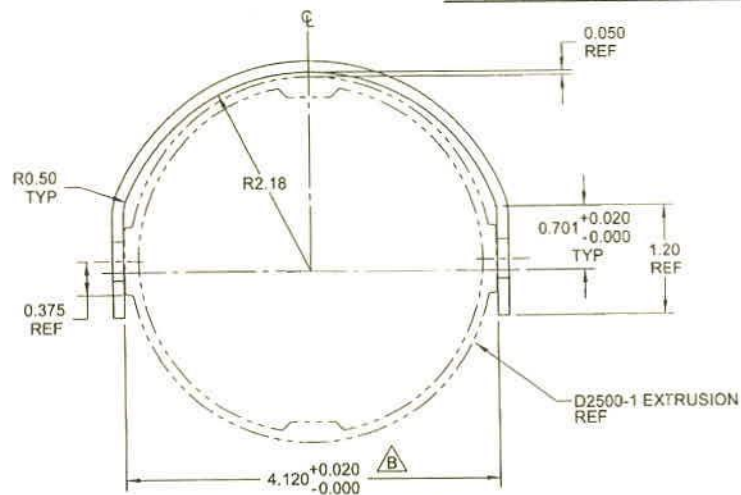
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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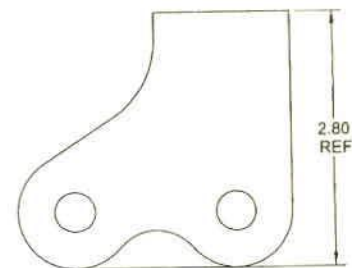
RELEASED



D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
06/12/14

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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